

Date: Tuesday, 04/07/2006 12:36:11 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DECK PLATE,FWD ,350 LITTER KIT
<b>Job Number</b> : 27737	
<b>Estimate Number</b> : 11104	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2364
<b>This Issue</b> : 04/07/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2364 REV.F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 28/06/2006 <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F
<b>Previous Run</b> :	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 22/07/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : EST. REV. E 00.06.26 Removed P/O for powder coat EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S063	2024-T3 .063 sheet
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**Comment:** Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s)  
 2024-T3 .063 Aluminum sheet  
 (M2024T3S063)  
 Batch: M101022

M.L. 06 07 11

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

M.L. 06 07 11

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M.L. 06 07 12

(8)

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

J. 06-07-20 (8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 Deburr

M.F. 06/07/28

(8)

6.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING / Acid etch & Alodine  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M.F. 06/07/31  
SC 06/07/31 (8)

(8)

Date: Tuesday, 04/07/2006 12:36:11 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PU 4/8/01 (5)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST173*

*LB 06/08/01 (8)*

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*D 06/08/02 (8)*

Job Completion



*C 206/08/01*

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: DECK PLATE,FWD ,350 LITTER KIT
<b>Job Number</b>	: 27737		
<b>Estimate Number</b>	: 11104		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2364
<b>This Issue</b>	: 6/28/2006 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D2364 REV.F
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b>	: F
<b>Previous Run</b>	:	<b>Material</b>	:
<b>Written By</b>	: _____	<b>Due Date</b>	: 7/22/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: _____		
<b>Comment</b>	: EST. REV. E    00.06.26    Removed P/O for powder coat    EC		

## Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 M2024T3S063 2024-T3 .063 sheet

**Comment:** Qty.: 0.6792 sf(s)/Unit    Total : 5.4340 sf(s)  
2024-T3 .063 Aluminum sheet  
(M2024T3S063)  
Batch: *M101022*

2.0 SHEAR

**Comment:** SHEAR

Cut blanks: 13.70" x 6.80" +0.045/-0.000

3.0 ~~HAAS1~~ *Water Jet* HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1-  
Machine D2364 as per Folio D2364 and Dwg D2364

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

**Comment: SECOND CHECK**

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Deburrr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:17:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 27737

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 06/08/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 27737
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b> D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.625	✓		VERN	
Ø0.171	+0.005/-0.000	0.171	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
11.242	+/-0.010	11.245	✓		Height Gauge	
3.031	+/-0.010	3.037	✓		VERN	
1.903	+/-0.010	1.906	✓		VERN	
1.128	+/-0.010	1.130	✓		VERN	
0.354	+/-0.010	0.353	✓		VERN	
1.340	+/-0.005	1.343	✓		VERN	
2.326	+/-0.010	2.327	✓		VERN	
3.312	+/-0.010	3.313	✓		VERN	
4.298	+/-0.010	4.299	✓		VERN	
5.284	+/-0.010	5.284	✓		VERN	
6.151	+/-0.010	6.151	✓		VERN	
6.270	+/-0.010	6.270	✓		VERN	
0.354	+/-0.010	0.356	✓		VERN	
3.031	+/-0.010	3.037	✓		VERN	
Ø0.656	+0.005/-0.000	0.656	✓		VERN	
5.003	+/-0.010	5.003	✓		VERN	
4.605	+/-0.010	4.607	✓		VERN	
1.776	+/-0.010	1.779	✓		VERN	
0.980	+/-0.010	0.978	✓		VERN	
4.487	+/-0.010	4.492	✓		VERN	
7.192	+/-0.010	7.198	✓		VERN	
7.597	+/-0.010	7.573	✓		VERN	
7.942	+/-0.010	7.948	✓		VERN	
Ø0.191	+0.005/-0.000	0.191	✓		VERN	
Ø0.197	+0.005/-0.000	0.197	✓		VERN	
11.145	+/-0.010	11.149	✓		VERN	
12.181	+/-0.010	12.183	✓		Height Gauge	
11.378	+/-0.010	11.375	✓		Height Gauge	
11.776	+/-0.010	11.780	✓		Height Gauge	
12.173	+/-0.010	12.176	✓		Height Gauge	
4.690	+/-0.010	4.693	✓		Height Gauge	
0.250	+0.005/-0.000	0.250	✓		VERN	
3.1413.144	+/-0.010	3.151	✓		VERN	
0.171	+0.005/-0.000	0.171	✓		VERN	

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/07/12	<b>Date:</b> 06/07/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	[Signature]

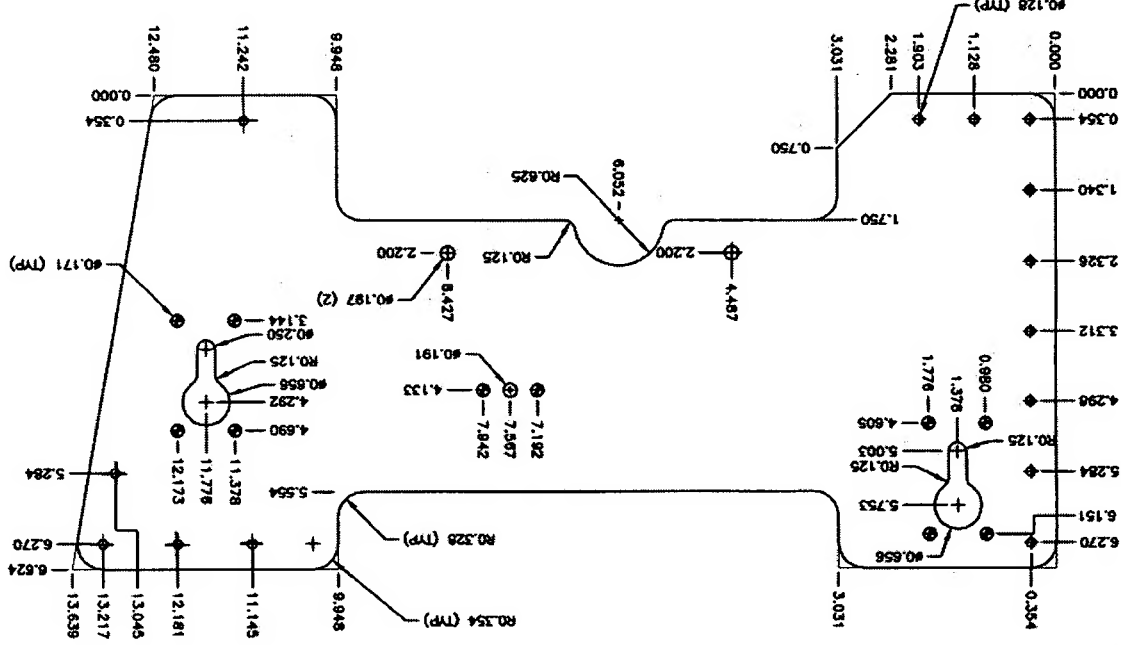
**DART**



DESIGN		DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>		DRAWING NO. D2364	REV. F SHEET 1 OF 1
DATE 98.06.19		TITLE LITTER DECK PLATE, 350		
A	95.01.14	NEW ISSUE		
B	95.02.09	MOVED KEYWAY		
D	95.03.06	0.191 WAS 0.197		
E	95.10.06	GEOMETRY CHANGES		
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)		

**RELEASED**  
R 98/06/22 LG

COUNTER SINK HOLES:  
♦ C'SINK Ø0.225 x 100°  
● C'SINK Ø0.308 x 100°  
(UPDATED FROM 9 TO 14 HOLES BY 05 99.03.01 TO CORRECT CAD ERROR)



MATERIAL: 2024-T3 (00-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
DIMENSIONS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 27737